

Work Order ID 133512

Monday, June 08, 2015 3:46:52 PM

133512

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 6/08/15

Start Qty: 50.00

50

Cust Item ID:

Required Date: 6/08/15

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: MCSDate: JUN 10 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3537

D

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D3537-1 as per Dwg D3537

Dwg Rev: DProg Rev: D

2-Deburr if necessary

(50) 06/15/06/10

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(50) 06/15/06/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 133512

Monday, June 08, 2015 3:46:52 PM

133512

Page 2

Item ID: D3537-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 6/08/15

Start Qty: 50.00

50

Cust Item ID:

Required Date: 6/08/15

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89
JUN 11 2015

140

Form as per dwg
NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

JUN 15 2015

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

JUN 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Work Order ID 133512

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133512

Page 3

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 6/08/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 6/08/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M131995</u> Large Fab	0.00				<u>x30</u>	<u>MAL/ABL</u>	<u>15-07-07</u>	
	Memo	0.00							
	A/R 2059B Hardcoat BATCH: <u>M131995</u>								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				<u>(30)</u>			DAS 38 9-89 JUL 07 2015
	Memo	0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				<u>(30)</u>			DAS 38 9-89 JUL 07 2015
	Memo	0.00							

P.T.O.

DQA: Aut Date: 15/07/10

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPH Date: 15/07/10Work Order update only ☐

Work Order: <u>133512</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3537-1</u>	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>15-5186</u>	Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☒	Composite ☐	Supplier ☐	<u>RED</u>	
Date: <u>15-07-07</u>	Step #: <u>160</u>	QTY Effective: <u>20</u>			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			DAS 9 9-89 <u>15-07-07</u>	
Take 20 for Robot (testings)		Scrap/destroy no replace (test) RECEIVED 20 to stock and Issue to Robot w/o <u>15-7-8</u>			Completed By DAS 38 9-89 <u>15-7-2015</u>	
					Lead hnd / Supervisor Approval Verification <u>15-7-7</u>	
					QC / QA Coordinator Approval DAS 9 9-89 <u>15-07-07</u>	
Root Cause		FAULT CATEGORY				
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐					
Misidentified ☐	Past Due ☐	OTHER: <u>Test Robot</u>				

Work Order ID 133512

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133512

Page 4

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 6/08/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 6/08/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: FP-001	0.00							
210									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

Handwritten: ~~30~~ 30 / ~~21~~ 21 12/07/07

Handwritten: MJS JUL 08 2015

Handwritten: MJS JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

Picklist Print

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Page 1

Work Order ID: 133512

133512

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	240.3076	0.106	6			

M304S16GA

304/316 Sheet .063

06/15/06/10

Location

Loc Qty

Loc Code

MAT019

240.3076

m131384

95.0176

m131503

145.29

6.2

DQA: _____ Date: _____

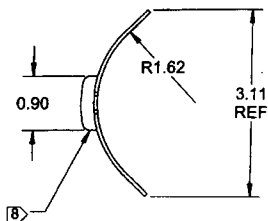


WORK ORDER NON-CONFORMANCE / UPDATE

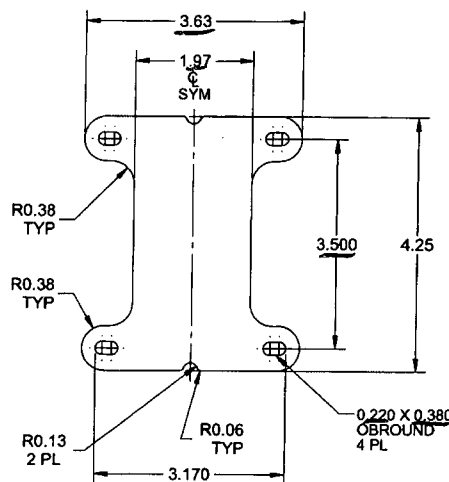
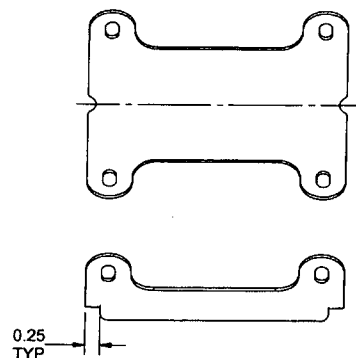
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



D3537-1 WEARPAD
(MAKE FROM D3537-1F)

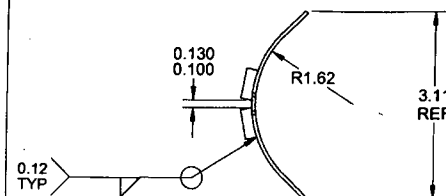


D3537-1F FLAT PATTERN

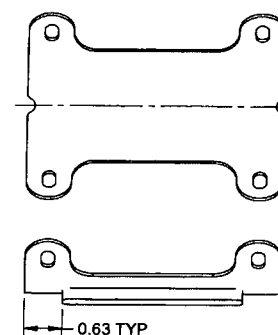
- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.42 lbs
 - 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
 - 9) WELDING: PER QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

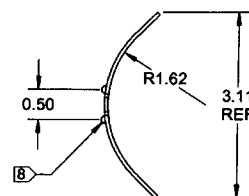
133512 MJS
1506-10



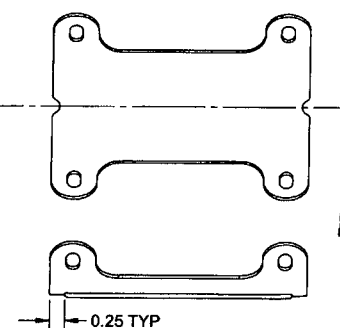
D3537-5 WEARPAD
(MAKE FROM D3537-1F)



- NOTES:**
- 1-5) AS PER D3537-1
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.42 lbs
 - 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
 - 9) WELDING: PER QSI 004



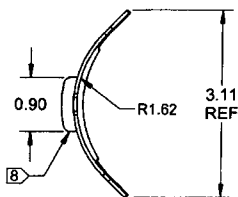
D3537-9 WEARPAD
(MAKE FROM D3537-1F)



- NOTES:**
- 1-5) AS PER D3537-1
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
 - 7) WEIGHT: 0.19 lbs
 - 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
 - 9) WELDING: PER QSI 004
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

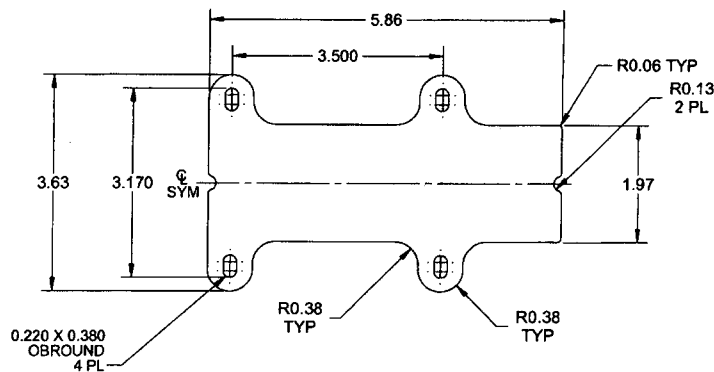
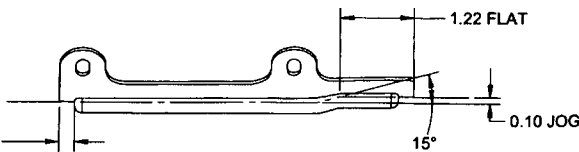
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	14.10.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2014-11-05



D3537-3 WEARPAD
(MAKE FROM D3537-3F)

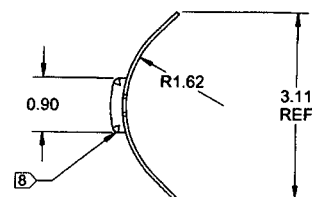
0.25 TYP



D3537-3F FLAT PATTERN

NOTES:

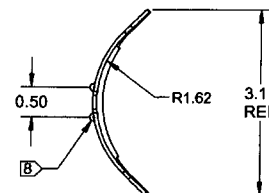
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-7 WEARPAD
(MAKE FROM D3537-3F)

NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.50 lbs
- 8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
- 9) WELDING: PER QSI 004



D3537-11 WEARPAD
(MAKE FROM D3537-3F)

NOTES:

- 1-5) AS PER D3537-3
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.25 lbs
- 8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
- 9) WELDING: PER QSI 004
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

APPROVED	DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	DB		
	CHECKED	DW	DRAWING NO.	REV. D
	MFG. APPR.	DD	D3537	SHEET 2 OF 2
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	WEARPAD	NTS
DATE		14.10.16		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

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2014-11-05

